



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3013
Job Sheet 186715



✓
load

Part No: 646.3013

Job Qty: 4 ea
20ea
DAS 21
9-89

Part Name: Blade



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/20/18

Job Tracking No:

Due Date: 12/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV N/C SHEET 10 IPP REV:A NEW ISSUE 12/11/09 JFS VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	12/28/18	12/28/18	0.00	0.00	Start Up Machining-1		mark 18/12/11
100	Bandsaw	4 pcs	12/28/18	12/28/18	0.00	0.07	Bandsaw1		11
110	CNC Vertical Machining	4 pcs	12/28/18	12/28/18	0.13	3.62	HAAS1-1		mark 18/12/15
120	QC	4 pcs	12/28/18	12/28/18	0.00	0.00	QC2 Machining-1		11
130	QC	4 pcs	12/28/18	12/28/18	0.00	0.00	QC8 Machining-1		B-a 18-12-18
140	Outsource	4 pcs	12/28/18	12/28/18			MEI001-VC	5	CT18-12-218
150	Packaging	4 pcs	12/28/18	12/28/18	0.00	0.00	Packaging2		JAN 14 2019
155	QC	4 pcs	12/28/18	12/28/18	0.00	0.00	QC6		38
160	SprayPaint	4 pcs	12/28/18	12/28/18	0.00	0.15	Spray Paint		*AB 19-1-18
170	QC	4 pcs	12/28/18	12/28/18	0.00	0.00	QC14		38
180	Packaging	4 pcs	12/28/18	12/28/18	0.00	0.00	Packaging3-1		9-89
190	QC21-SA	4 Ea	12/28/18	12/28/18	0.00	0.00	QC21		6

Part Op 100 - Cut Blank at 4.930"

Descriptions: 110 - 1-Machine per folio FB150 2- deburr and break all sharp edges except otherwise noted KNIFE EDGE MUST BE SHARPENED USING STONE REMOVE ALL BURRS ON CUTTING EDGE

140 - ISSUE P/O 042098 FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS As Per Dwg 646.3000 PART ARE MADE FROM AISI A2 TOOL STEEL

160 - PRIME AS PER DWG, SEE NOTE #4 PRIMER BATCH: 5138981

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MSTEEL-A2-B0.500X1.250	AISI A2 Tool Steel Bar, 0.500 X 1.250	1.6440 ft (.411 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MSTEEL-A2-B0.500X1.250	2	37	0

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Specifications

Limits	Type	Special Comments
0.380		
0.370		



Container No: S136656



Part: 646.3013

Job No: 186715

Serial No/Batch: S136656

Plex 11/20/18 1:08 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐
Part No. _____		
NCR No. _____		

Date : _____ Step #: _____ QTY Effective: _____

Description Work Order Deviation

QC / QA Coordinator
Approval

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

2	Blade	66.500Degrees ± 0.500	67.000 66.000	Angle
3	Blade	0.177inches + 0.005 - 0.001	0.182 0.176	Diameter
4	Blade	4.800inches + 0.010 - 0.001	4.810 4.799	
5	Blade	4.396inches ± 0.005	4.401 4.391	
6	Blade	0.576inches ± 0.005	0.581 0.571	
7	Blade	45.000Degrees ± 0.500	45.500 44.500	Angle
8	Blade	0.635inches ± 0.002	0.637 0.633	
9	Blade	1.109inches ± 0.002	1.111 1.107	
10	Blade	0.240inches ± 0.002	0.242 0.238	
11	Blade	0.576inches ± 0.005	0.581 0.571	
12	Blade	0.940inches ± 0.010	0.950 0.930	
13	Blade	0.125inches ± 0.005	0.130 0.120	Radius
14	Blade	60.000Degrees ± 0.500	60.500 59.500	Angle
15	Blade	0.325inches ± 0.005	0.330 0.320	
16	Blade	30.000Degrees ± 0.000	30.000 30.000	Angle

Plex 11/20/18 1:08 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042098



Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

PO No: PO042098
PO Date: 12/18/18
Due Date: 1/11/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185776	646.3316	Blade HEAT TREAT AS PER DWG 646.3300 FINISH: HEAT TREAT TO 58- 62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED	Firmed	-	1/11/19	30 pcs	0 pcs	30 pcs	\$4.4571428/pcs	\$133.71

Line Item Note **need as soon as possible**

2	186716	646.3014	Blade HEAT TREAT AS PER DWG, SEE NOTE #3	Firmed	-	1/11/19	20 pcs	0 pcs	20 pcs	\$4.4571428/pcs	\$89.14
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042098



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	186715	646.3013	Blade ISSUE P/O: FINISH: HEAT TREAT TO 58- 62 RC ROCKWELL HARDNESS As Per Dwg 646.3000 PART ARE MADE FROM AISI A2 TOOL STEEL	Firmed	-	1/11/19	20 pcs	0 pcs	20 pcs	\$4.4571428/pcs	\$89.14
Grand Total:											\$312.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/11/19 1:32 PM dart.tsimiklis.chrisoula

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL	EXPÉDITEUR	BON D'EXPÉDITION
Order	Shipper ID	Shipper
332982	1	133777

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

LIVRÉ À /Shipped To

DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



COMMANDE DU CLIENT	BON DE LIVRAISON DU CLIENT	TYPE DE MATÉRIEL	DATE DE LA COMMANDE	TRANSPORTEUR
Customer PO	Customer Shipper No.	Material Type	Order Date	Carrier
42098 ✓		A2	2018/12/19	client

QUANTITÉ	No. PIÈCE	NOM DE LA PIÈCE	DESCRIPTION DE LA PIÈCE	POIDS
Quantity	Part No.	Part Name	Part Description	Weight

✓ 70 646.3316 27,
(30) 646.3316 JOB 185776 ✓
(20) 646.3014 JOB 186716 ✓
(20) 646.3013 JOB 186715 ✓

1 VALISE

DAS
38
8-89

TYPE DE CONTENEUR	# DE CONTENEURS	COMMENTAIRES CONTENEUR
Container Type	# Of Containers	Container Comments
VALISE	1	

certificat

EXPÉDIÉ PAR: Shipped by:	
-----------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 70

POIDS EXPÉDIÉ / Weight Shipped : 27,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RÉSTANT / Weight Remaining : 0,00

APPROUVÉ

certificat

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 70

POIDS EXPÉDIÉ / Weight Shipped : 27,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2019/01/11

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détail

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
332982	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
42098	N/A	A2		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
VAC HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed		RÉSULTATS DE TESTS / results	
HARDNESS	58 - 62 HRC		11	61 - 62 HRC
(907)				
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
70	27	646.3316 (30) 646.3316 JOB 185776 (20) 646.3014 JOB 186716 (20) 646.3013 JOB 186715 1 VALISE		

COMMENTAIRES / comments

VAC HARDEN 1800F, 1 HR
DOUBLE TEMPER 400F, 2 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Ce document et les documents qui lui sont joints peuvent contenir des informations confidentielles, être soumis aux réglementations relatives au contrôle des exportations ou ayant un caractère privé. S'ils ne vous sont pas destinés, nous vous signalons qu'il est strictement interdit de les divulguer, de les reproduire ou d'en utiliser de quelque manière que ce soit le contenu. Toute exportation ou réexportation non autorisée est interdite.

Sabiel Otero
Technician
METCOR
12

DAS
38
9-89

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
332982	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
42098 ✓	N/A	A2		

SPÉCIFICATIONS DU PROCÉDÉ processing specifications

VAC HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	58 - 62 HRC	11 (907)	61 - 62 HRC

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
✓ 70	27	646.3316 ✓ (30) 646.3316 JOB 185776 ✓ (20) 646.3014 JOB 186716 ✓ (20) 646.3013 JOB 186715 ✓ 1 VALISE

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

DATE: 2019-01-11

Pierre Piché
Chief Inspector



APPROUVÉ

DAS
38
9-89